

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021044**Date Inspected:** 05-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Ai Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay #1

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as E2-SB1-031-090, located on Steel Barrier, E5-SB5-031, welder is identified as 216575, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint identified as E2-SB1B-043-026, located on Steel Barrier, E2-SB1B-043, welder is identified as 215218, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB

FCAW welding of weld joint identified as E2-SB2-058-057, located on Steel Barrier E2-SB2-058, welder is identified as 068494, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint identified as E2-SB2-053-028, located on Steel Barrier, E2-SB2-032, welder is identified as 215082, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by

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## WELDING INSPECTION REPORT

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QC appeared to comply with WPS-B-T-2132-3.

OBG Bay #7

This QA Inspector observed the following work in progress:

FCAW welding of welding of weld joint identified as W2-SB10-035-019, located on Steel Barrier, E5-SB5-035, welder is identified as 04969, ZPMC Quality Control (QC) is identified as Mr. Shenjia gua. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G-(1F) Repair.

Bay 28

NDT

The following NDT performed ZPMC NDT notification 07630:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 09:30 hours. The members are identified as follows:

E2-SB13-037-098-019, E2-SB13-017-019, E5-SB5-001-019, E5-SB13-007-019, E2-SB13-103-080, E2-SB13-075-051, E5-SB20-107-081, E5-SB5-027-019, E5-SB5-062-080, E5-SB5-050-080, E5-SB5-046-080, E5-SB5-006-080, E2-SB1-090-080, E2-SB1-031-080, E2-SB1-037-051.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Humphrey, Delbert	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall, Steven	QA Reviewer

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